

Work Order ID 138964

Friday, November 13, 2015 11:37:04 AM

138964

Page 1

Item ID: D2894-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 2.75 Support

Start Date: 11/13/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MCS Date: NOV 17 2015

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2894	E								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA253
Tumble & Deburr

0.00

0.05

DAS

44
9-89

15/11/26

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

44
9-89

15/11/26

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

DAS

08
9-89

P.T.C.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>138964</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2894-1</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date: <u>15-12-08</u>	Step #: <u>100</u>	QTY Effective: <u>6</u>	MRB (QS1042) Approval <u>PD</u> <u>15-12-08</u>
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Description Work Order Deviation marks found inside of hole $\phi .500^{+.005}_{-.000}$	Disposition open hole to max tolerance SCRAP QTY (3) supports with trans. hole marks. High stress critical interface. See next ncr.	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
---	--	---

Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☒ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☒ Broken <u>Damage</u> /Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☒ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
OTHER : _____					

Work Order ID 138964

138964

Page 2

Friday, November 13, 2015 11:37:04 AM

Item ID: D2894-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 2.75 Support
 Start Date: 11/13/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG51</u>	0.00							DAS 41 9-80
130						3			16-1-7
Packaging	Memo	0.00							
Packaging	LOCATION : LG052								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

MLJ JAN 07 2016

MLJ JAN 07 2016

DQA:

Date:

16/01/15



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16/01/11

Work Order update only ☐

Work Order: <u>13896Y</u> Part No. <u>D2894-1</u> NCR No. <u>16-5513</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>16/1/5</u>	Step #: <u>100</u>	QTY Effective: <u>3</u>	MRB (QSI042) Approval DAS 12 16/1/5 9-89																																																																	
Description Work Order Deviation After opening holes to max tolerance, QTY (3) supports have transition marks. P.C. mark made from drilling. (insert drill)		Disposition SCRAP. ^{3Y} High stress/critical interface. no replace. - Changed Folio and prog. with drill and reamer instead of insert drill.		Completed By DAS 08 16/01/05 9-89 Lead hand / Supervisor Approval Verification D.A 16/01/05 QC / QA Coordinator Approval DAS 9 16-01-05 9-89																																																																
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☒</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☒	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☒</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>			Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☒	Misaligned/off center ☐	Turning Sequence ☐
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Picklist Print

Friday, November 13, 2015 11:37:03 AM

Page 1

Work Order ID: 138964

138964

Parent Item: D2894-1

D2894-1

Parent Item Name: 2.75 Support

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: B02.11.26Added mask holeKJ

IPP Rev:C ECN 993 07-11-07 DD verified by:EC

IPP D 08.03.19 Re-format EC verified by DD IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSK079

Manufactured

No

100

Each

3.0000

0.5

3

DAS

DSK079

44
9-89

15/11/26

D2894-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

3

126547

2

132240

1

2

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

DART AEROSPACE LTD		Work Order:	138964
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.463	.462	.461	.464	.464
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.778	1.779	1.779	1.779	1.780
AE	0.020	0.040		.020	.020	.020	.020	.020
AF	0.260	0.267		.261	.261	.261	.261	.261
AG	0.170	0.190		.180	.180	.180	.180	.180
AH	0.150	0.170		.160	.160	.160	.160	.160
AI	1.970	2.030		1.996	1.995	1.997	1.996	1.996
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.884	1.887	1.884	1.885	1.887
AL	0.500	0.505		.502	.503	.502	.502	.503
AM	0.188	0.194		.189	.189	.189	.189	.189
				.189	.189			
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.001	.003	.0015	.003	.003

Measured by:	DAS 44 9-89	Date:	15/11/26
Audited by:	DAS 08 9-89	Date:	16/01/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	

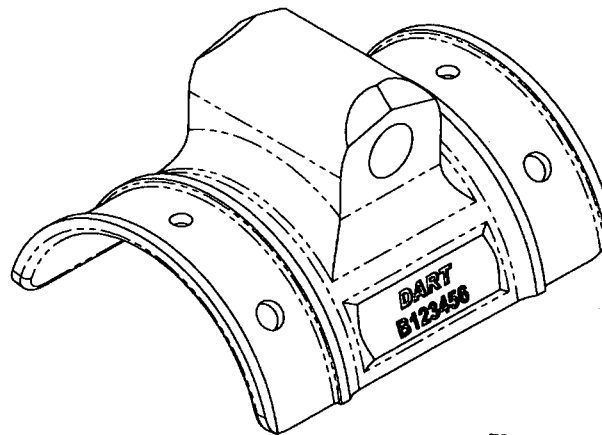
DART AEROSPACE LTD		Work Order:	138964
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

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AB	3.062	3.082		3.072				
AC	0.053	0.073		0.063				
AD	1.766	1.786		1.780				
AE	0.020	0.040		0.020				
AF	0.260	0.267		0.261				
AG	0.170	0.190		0.180				
AH	0.150	0.170		0.160				
AI	1.970	2.030		1.997				
AJ	0.240	0.260		0.250				
AK	1.880	1.900		1.888				
AL	0.500	0.505		0.503				
AM	0.188	0.194		0.189				
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				0.000				

Measured by:	DAS 44 9-89	Date:	15/11/26
Audited by:	L.D. 08 9-89	Date:	16/01/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	



D2894-1 Ø2.750 SUPPORT

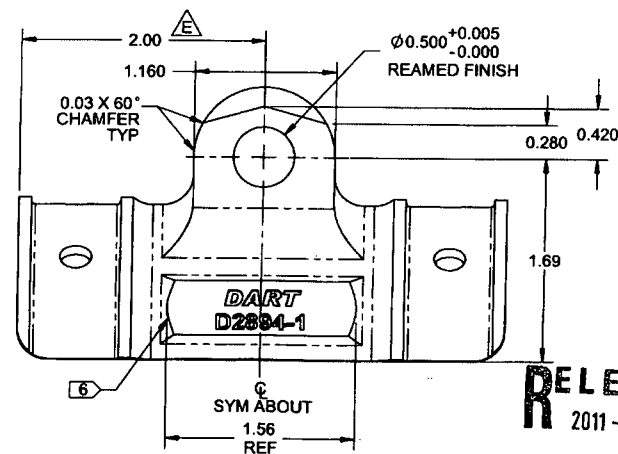
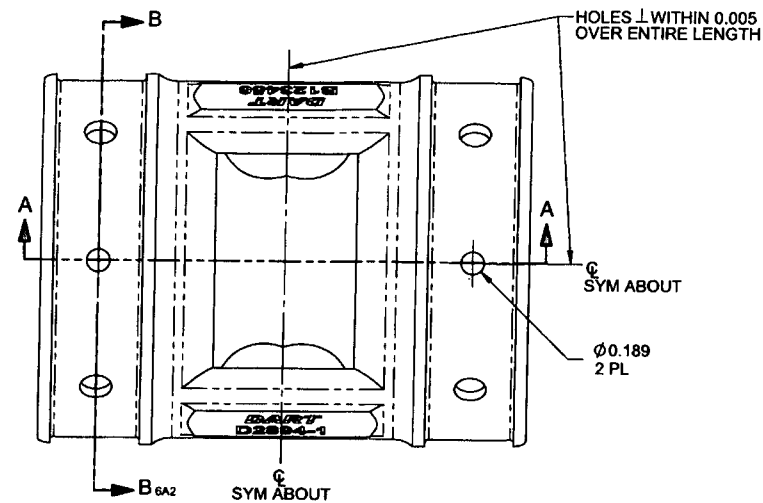
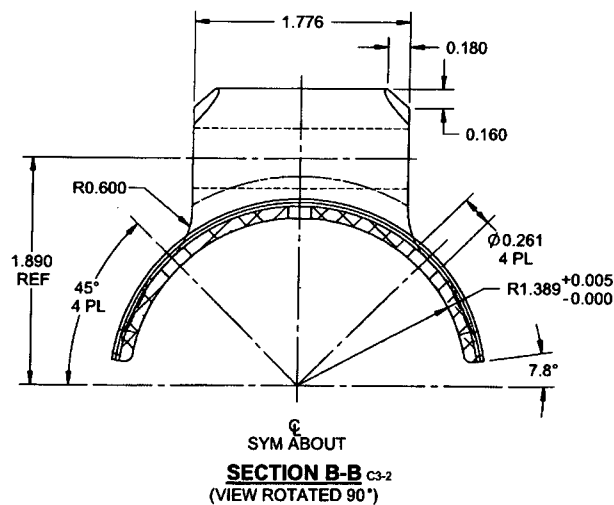
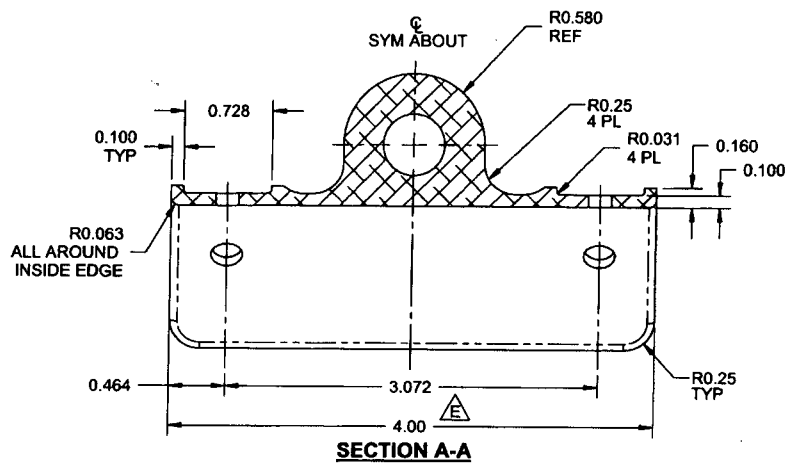
138964 MJS
15-11-17

RELEASED
2011-09-29
JMT

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MATL SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C8-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 Ø.281 HOLE WAS Ø.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D2894-1 Ø2.750 SUPPORT

RELEASED
2011-09-29

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
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